

Work Order ID 79081

79081

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January-19-12 1:41:26 PM

Item ID: D2803-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket
 Start Date: 19/01/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 02/02/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: H.L.J. Date: 12/01/19 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2803	Rev B								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per FILE D2803-1								
6061 .850 x 1.0	Dwg Rev: B								
	Prog Rev: B								
	2-Deburr if necessary								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per folio FA102								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

MAT NOT PULL

B12-1-25

8

36/29

12/01/30

B12-1-25

*PTC

36/29

12/01/30

8

8

Dart Aerospace Ltd

W/O:		79081						WORK ORDER CHANGES	
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: D2803-1 PAR #: Fault Category: Small FAD / Data NCR: Yes No DQA: Aut Date: 12/2/14
 Resolution: Acceptable use on - is Disposition: Acceptable use on - is Set QA: N/C Closed: OK Date: 12/2/14

NCR: 12-1191		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/10/14	110	Mat'l missing from outside profile. Re. cut on w/s. process	S 12/10/14 052042	Acceptable per D.S. email that attached	SG 12/10/14	S 12/10/14	S 12/10/14 052042	S 12/10/14

NOTE: Date & initial all entries

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 Required Date: 02/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	B.A	12/01/30		8	0		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				8	BL 12-2-7.		
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				8X 0 M	12/02/07		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>148</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

[Handwritten signature] M.C.J. 12/02/08

M.C.J. 12/02/08
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January-19-12 1:41:30 PM

9,5734

Page 1

Work Order ID: 79081

79081

Parent Item: D2803-1

D2803-1

Parent Item Name: Bracket

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP A00.11.06New IssueEC

IPP Rev:B Blanks Now Cut on Waterjet 06-06-14 JLM

IPP Rev:C Removed Tumbling 08-09-10 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B0.500X10.00
0

Purchased

No

100

f

24.1000

1.9167

8.070316

15.5

M6061T6B0 500X10 000

**

B12-1-25

6061 T6 Bar 500 x 10.00

Location

Loc Qty

Loc Code

MAT004

24.1

119513

24.1

M6061T6B.500x12.00

118641

8

This Butel only
Jan/12-01-25

500X 12

118641

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	79081
Description: Bracket		Part Number:	D2803-1
Inspection Dwg: D2803 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	.758	✓		Dial Caliper	B6 05
Ø0.191	+0.005/-0.000	.191	✓			
Ø0.507	+0.000/-0.001	.5065	✓			
13.558	+/-0.010	13.558	✓			
Ø0.507	+0.000/-0.001	.5065	✓			
12.411	+/-0.010	12.411	✓			
2.654	+0.000/-0.001	2.654	✓			
0.437	+0.000/-0.001	.437	✓			
1.420	+/-0.001	1.420	✓			
6.933	+/-0.010	6.933	✓			
0.250	+/-0.010	.252	✓			
0.875	+0.000/-0.001	.8475	✓			
0.250	+0.000/-0.005	.247	✓			
0.125	+/-0.010	.126	✓			
0.125	+/-0.010	.127	✓			
0.125	+/-0.010	.128	✓			
0.125	+/-0.010	.129	✓			
0.500	+/-0.010	.502	✓			
0.562	+/-0.010	.563	✓			
0.188	+/-0.010	.188	✓			

Measured by:	BK/PA
Date:	12/01/30

Audited by:	B.A
Date:	12/01/30

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	07.07.18	12.625 dimension removed	KJ/JLM	B

W/O:		WORK ORDER CHANGES					
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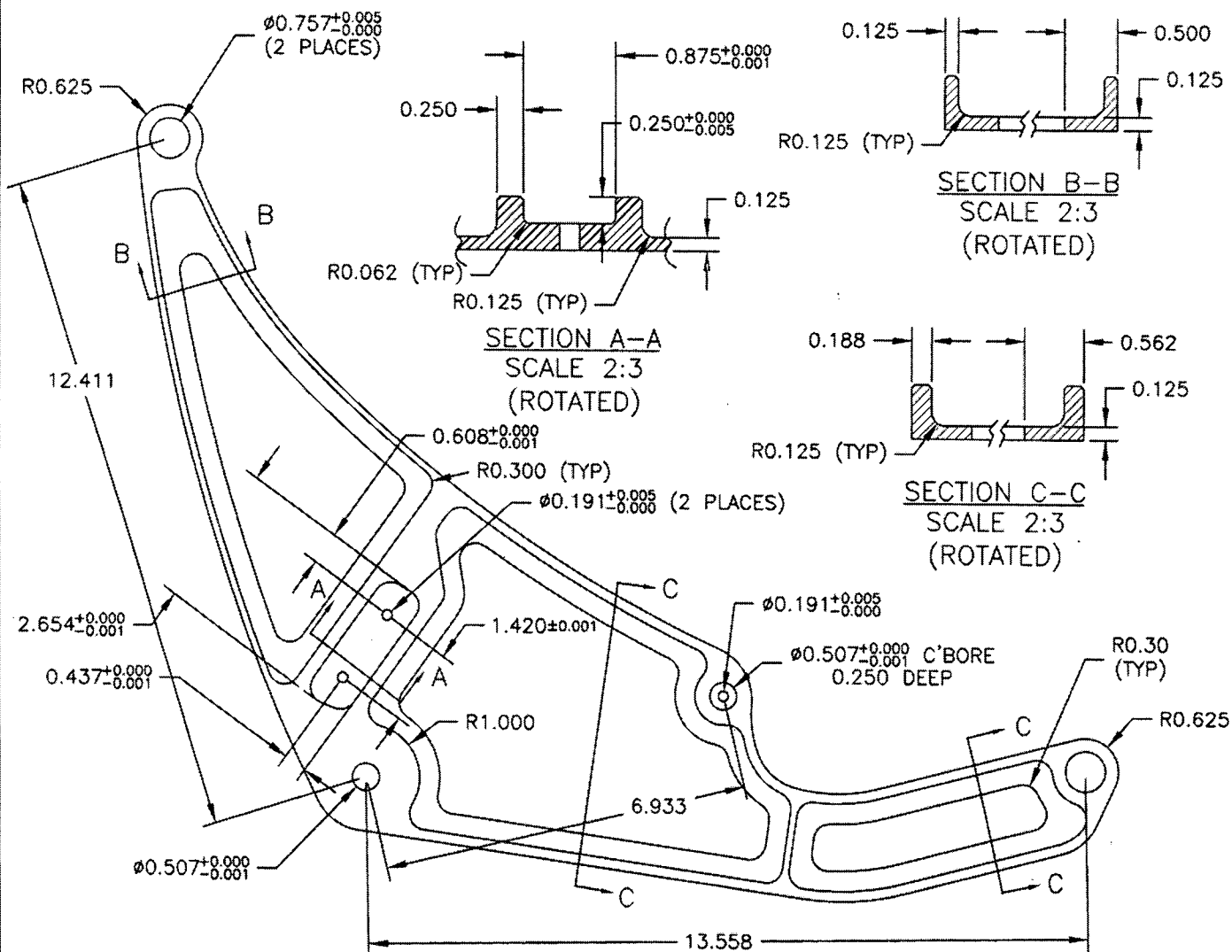
NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. B
				D2803	SHEET 1 OF 2
DATE	04.11.22			TITLE	SCALE
				STA 84 BRACKET	1:3
A	00.11.07			NEW ISSUE	
B	04.11.22			ADD CUTOUTS & -043/-044	

RELEASED

05-03 11 *[Signature]*



D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

STOP
RETURN
ELECTRONIC
UNCONTROLLED
SUBJECT
WITH
NO. 79081
12/01/19

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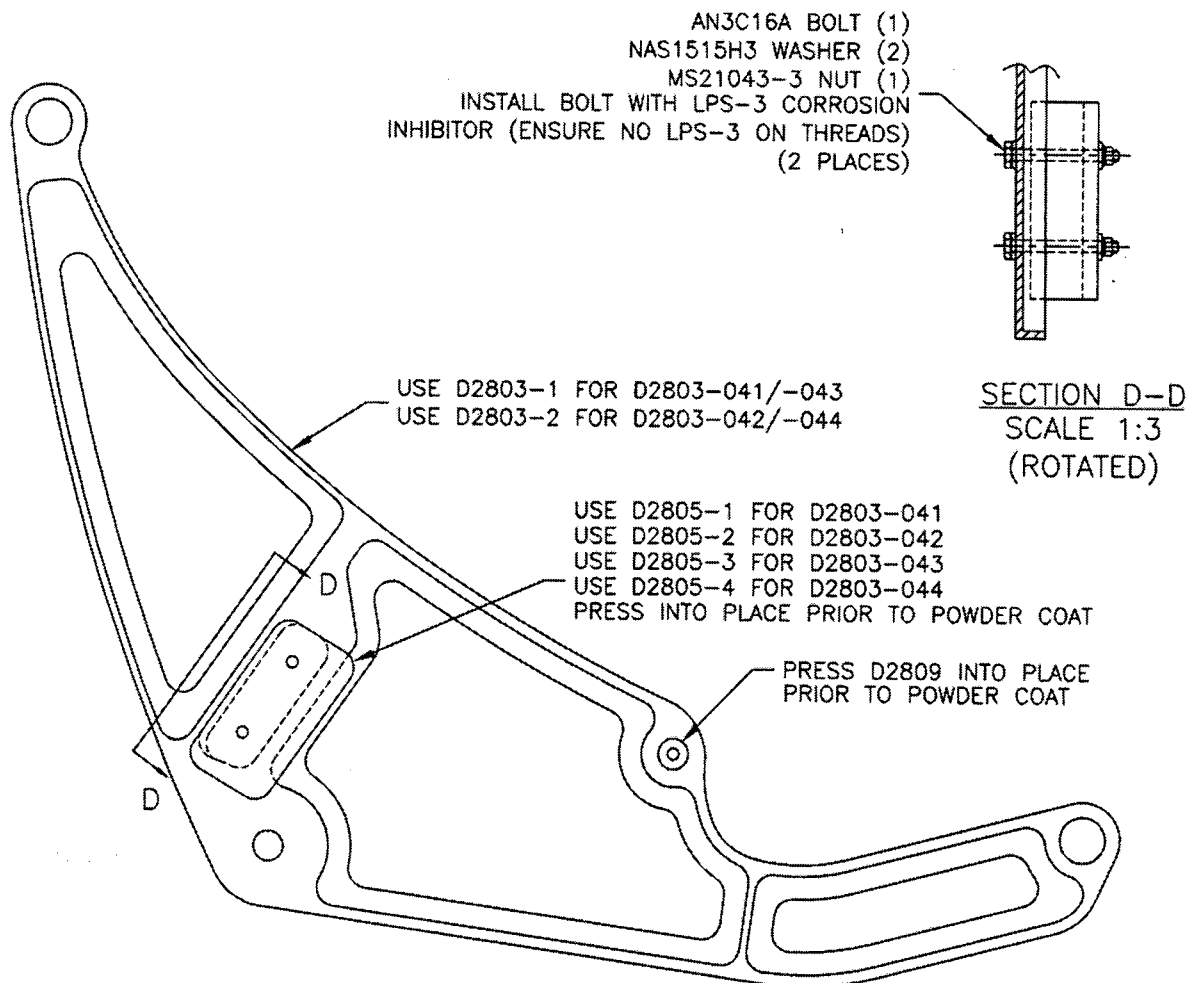
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NOTE: Date & initial all entries



79081

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



RELEASED

05-03.11

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Eric Downing

From: David Shepherd <dshepherd@dartaero.com>
Sent: February 7, 2012 12:13 AM
To: 'Marc Bellavance'
Cc: 'Downing, Eric'
Subject: RE: D2803 Bracket

Marc,

Sorry for the slow response on this ... Based on your analysis, this is an acceptable deviation.

David

From: Marc Bellavance [<mailto:mbellavance@dartaero.com>]
Sent: February-06-12 1:42 PM
To: Shepherd, David
Cc: Downing, Eric
Subject: RE: D2803 Bracket

Hi David,

Just a friendly reminder on this one...

Thanks,

Marc Bellavance

Technical/Shop Support

T. 613-632-5200 | C. 613-676-0992 | F. 613-632-9311

1270 Aberdeen Street, Hawkesbury, Ontario, Canada, K6A 2K7



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Please consider your environmental responsibility before printing this e-mail.

From: Marc Bellavance [<mailto:mbellavance@dartaero.com>]
Sent: Monday, January 30, 2012 11:08 AM
To: Shepherd, David
Cc: Downing, Eric
Subject: D2803 Bracket

Hi David,

A non-conformance was reported to me re part in subject line. I've marked up a page from our IIN to show the discrepancy.

As discussed with Chris, this is probably OK on the basis of the direction/application of the load around that area but he suggested I run this by you. I've also worked the numbers based on SR-P447-1, attached.
Please let me know if this is acceptable or not.

Marc Bellavance

Technical/Shop Support

T. 613-632-5200 | C. 613-676-0992 | F. 613-632-9311

1270 Aberdeen Street, Hawkesbury, Ontario, Canada, K6A 2K7



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